

Date: Wednesday, 21/05/2008 8:48:13 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : INBOARD WINDOW DOUBLER

Job Number : 38828

Estimate Number : 13147

P.O. Number :

Part Number : D37001

This Issue : 21/05/2008 S.O. No. :

Drawing Number : D3700 PRELIM

Prsht Rev. : NC

Project Number : N/A

First Issue : 28/04/2008 Type : SMALL /MED FAB

Drawing Revision : PRELIM

Previous Run : 37133

Material :

Due Date : 05/05/2008

Qty: ② Um: Each

Written By : _____

Checked & Approved By : _____

Comment : Est Rev:A 08-01-30 new issue DD verified by:

Additional Product

PROTOTYPE **PRELIMINARY ISSUE**

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.2984 sf(s)/Unit Total : 0.2984 sf(s)

6061T6 aluminium sheet .080" thick

(M6061T6S080)

Batch: 107276

HB 8-5-1

107904

107276

HB 8-5-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3700

Dwg Rev: PREL

Prog Rev: PREL

HB 8-5-1

PREL
PREL HB 8-5-22

①

PTO

2- Deburr if necessary

HB 8-5-1

HB 8-5-22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK **ENGINEERING APPROVAL**



Comment: SECOND CHECK

08-05-20

08.05.22

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

(not required)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-22	4	Scrap parts until no good Incorrect material received.	ls 08-05-22	Scrap + replace See NCR 08-046	See steps 1-4	See step 4	ls 08-05-22	08-05-22
				Rep here				

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Not required

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AB 08.05.21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



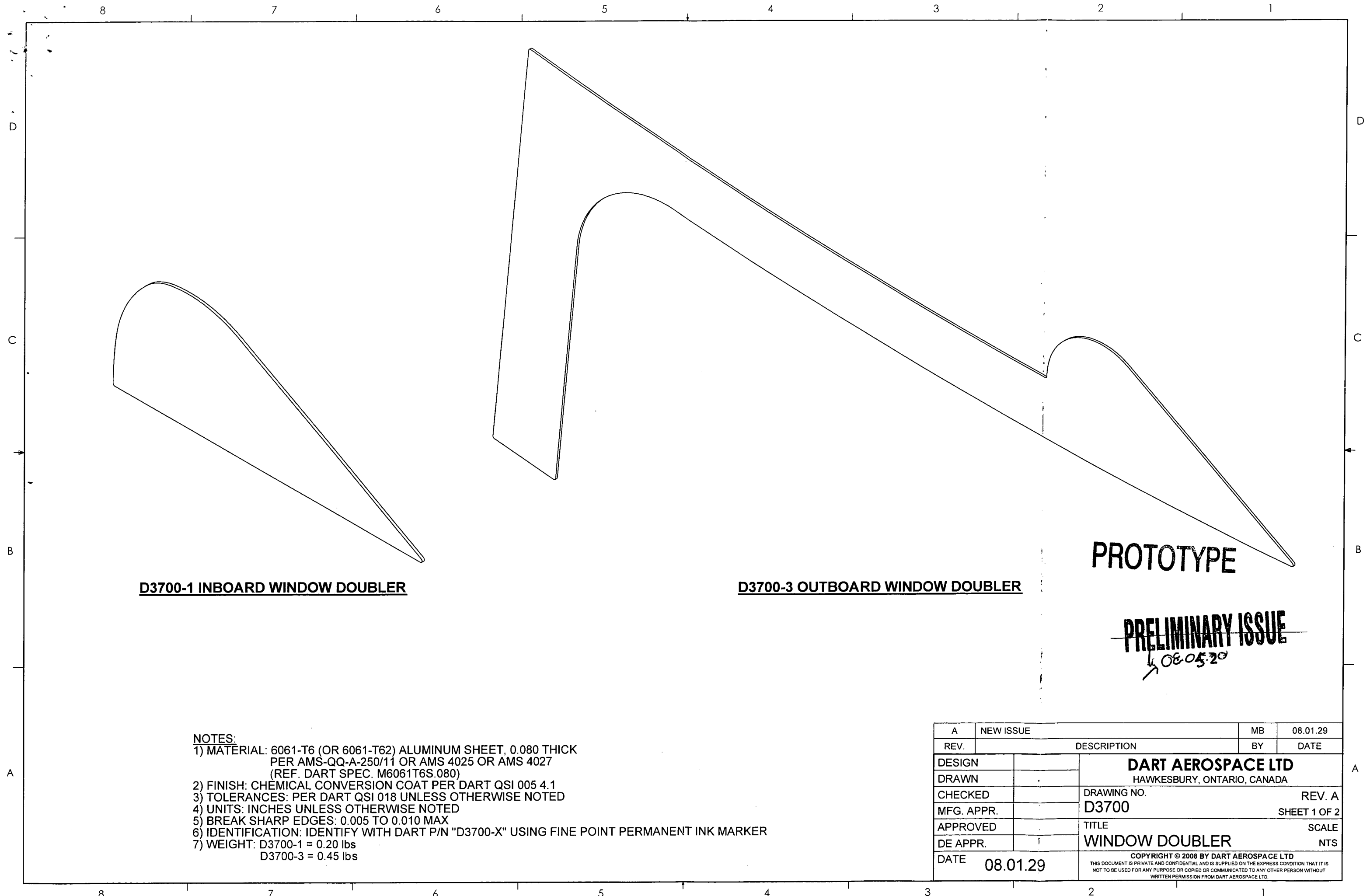
Comment: FINAL INSPECTION/W/O RELEASE

08.05.21 Prototype only

Job Completion



MF 08-06-13



D3700-1 INBOARD WINDOW DOUBLER

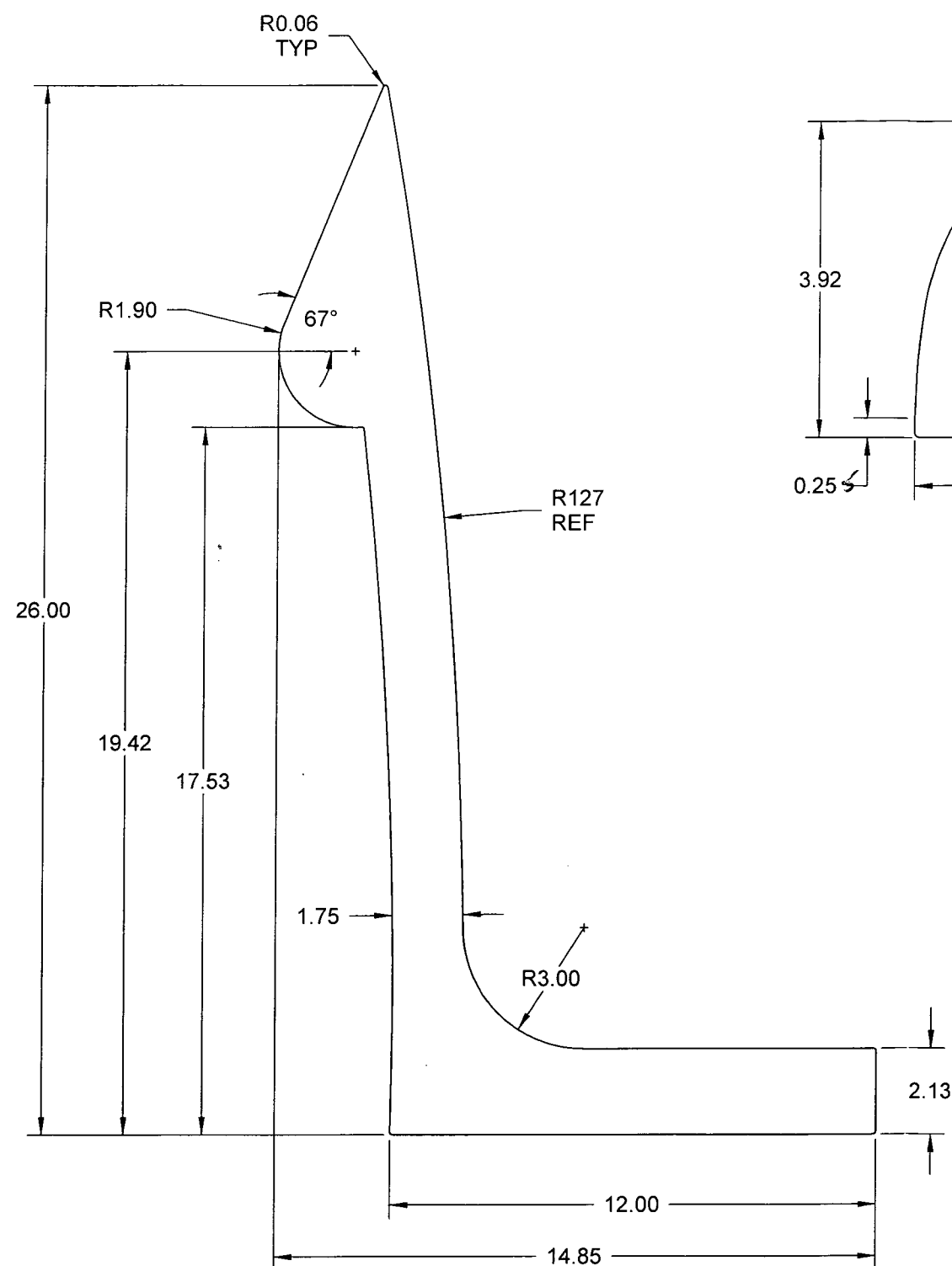
D3700-3 OUTBOARD WINDOW DOUBLER

PROTOTYPE

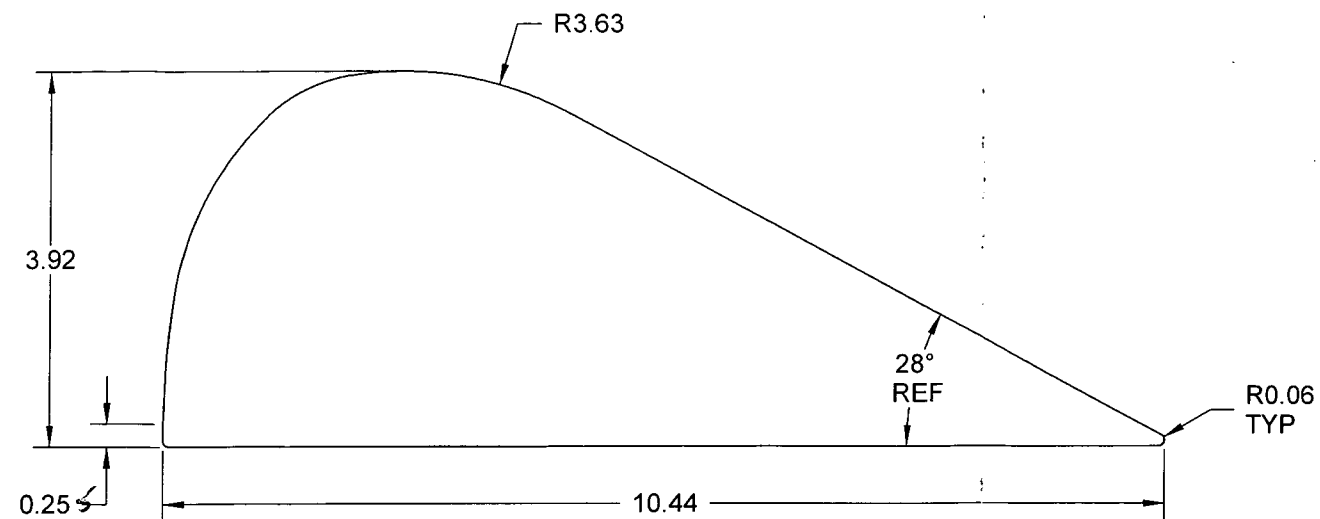
~~PRELIMINARY ISSUE~~
08.05.20

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3700-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3700-1 = 0.20 lbs
D3700-3 = 0.45 lbs

A	NEW ISSUE		MB	08.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO. D3700		REV. A
MFG. APPR.				SHEET 1 OF 2
APPROVED		TITLE WINDOW DOUBLER		SCALE
DE APPR.				NTS
DATE	08.01.29		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3700-3 OUTBOARD WINDOW DOUBLER



D3700-1 INBOARD WINDOW DOUBLER

PROTOTYPE

PRELIMINARY ISSUE
08.05.20

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3700	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW DOUBLER	NTS
DATE	08.01.29	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Receiving Report

Date: 8/5/2
Supplier: CAMP

Batch No: M/07904
Date P/O: 6/9/

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☒ No ☐
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐
Waybill Attached: Yes ☒ No ☐
Shipment Complete: Yes ☒ No ☐
QC6 Inspection 08/05/06
Work Order 08/05/06

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M6061T6B630X62		12	20	0	08	

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 08/05/06
Date: 08/05/06
Received/Costing: 08/05/06
Initial: [Signature]

Location _____

H:\FORMS\Purchasing\approved purchase\RECREPORT Rev D

7-4248
7-5696

MONTREAL : 514 336-4248
FAX : 514 336-4246

DISTRIBUTEUR D'ACIER ET METAUX SPECIALISES
STEEL AND SPECIALTY METALS DISTRIBUTOR

ONTARIO : 1 800 667-4248
FAX : 1 866 456-4242

On a du Savoir "FER"

SHIP TO: _____

PACE LTD
EEN STREET

FACTURE INVOICE	N° 188898
DATE	02/05/08
BON DE LIVRAISON PACKING SLIP	N° 134253
DATE DE LIVRAISON DELIVERY DATE	02/05/08

TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
NET 30 JOURS	2R		001

DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER *	MONTANT AMOUNT
3/4	36	365.000	CLB	02.133.16
080 X 144"	192	5.950		1142.40 ✓
3/4	4	350.000	CLB	02.15.47
HARGE	1	3.950	UN	- 20 3.95 C
POIDS TOTAL TOTAL WEIGHT		233		

Formplus N° 861

ALLS REMAIN THE PROPERTY OF "ACIER CAMP" INC. UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.
THE BUYER'S EXPENSE. • ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. • ANY DEFAULT IN RESPECT WITH PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE JLD. • ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. • ANY MERCHANDISE OR MODIFIED CANNOT BE RETURNED. • ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE HARGE.

N BONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

A / Y M / M J / D

CLIENT / CUSTOMER'S SIGNATURE

DATE

SOUS-TOTAL	1294.98
SUB TOTAL	
T.P.S. G.S.T.	64.75
T.V.Q. Q.S.T.	0.00
TOTAL	1359.73

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

Mark J. Vrablic

Mark J. Vrablic
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

876767

Ship Date

0

B.L. No.

Invoice No.

Alcoa No. Item

Page 1

2008-01-16

2726230

00000

4977123-3

P.O. No./COA Contract No.

Customer

Mfg. Order

N20523

Ship To:

Item Description

0.08 IN TK (+0 -.0045) X 48.0 IN W (+.046875 -.046875) (N) A/T 6061-T6 COIL SHEET FOR DISTRIBUTORS TOLERANCE GUARANTEED. AMS-QQ-A-250/11 AMS4027 REV M IS 2007 ASTM B209 REV 07 CMMPO19 REV D CMMPO25 REV Q CSTI008 REV D ((NOT MARKED)) LIGHTLY COILED COIL SIZES: ID 20 IN COIL WGT: MAX 5750 LB MAX GROSS SKID WGT: 6000 LB QUAN TOL +/-30 ± CQR 0211084 REV 02 CUST REQ 08-01-19 *** W/E 08-01-26 ***

Num	Package Ticket	Lot	Weight	Quantity	COM	Pc Id/Serl
1	603377	493536	4363	1	PC	:
2	603424	493536	4391	1	PC	:
			8754	2		

Notes for CQR: 0211084.2

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11F. PROD DCT PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 F ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11. Exception to Spec CMMPO19 ; Revan: D Issue: Letter dated 2006-09-28 from AHERN, DENNIS T to BLACKIE, BILL . Exception to Spec CMMPO25 ; Revan: Q Issue: Letter dated 2004-08-24 from STEGEMANN, JEAN to BLACKIE, B. . Exception to Spec CSTI008 ; Revan: D Issue: Letter dated 2006-12-04 from AHERN, DENNIS T to BLACKIE, BILL .

CQR: 0211084.2 -Specification Limits

Tempr	Dir	Max	Min	UTS		TYS		EL4D		Other		Other	
				KSI		KSI		PCT		Each		Total Aluminum	
T6	Long Transv.			42.0		35.0		10					
Chemical Composition				SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other
				Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05
				Min	0.40		0.15		0.8	0.04			REMAIN
Alloy 6061													
Lot: 493536				- Mechanical, Physical, Metallography, Quantometer Results									
				No->	UTS		TYS		EL4D				
				Test	KSI		KSI		PCT				
Tempr Dir					50.2		45.3		11				
T6 Long Transv.				2	50.6		45.3		11.4				

CERTIFIED INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

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Mark J. Vrabec

Mark J. Vrabec
Director of Manufacturing Davenport Works

Kathleen P. Young

Kathleen P. Young
Quality Assurance Manager

Ship From: RIVERDALE, IA.

Page 2

876767

0

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

2000-01-16

2726230

00000

4977123-3

P.O. No./Govt Contract No.

Customer

Big Order

N20523

SAMUEL SON & CO LT DCE-77123-3

Lot: 493536 - Mechanical, Physical, Metallography, Quantometer Results (cont.) -----
Cast Number Chemical SI FE CU MN MG CR ZN TI
H313506A Actuals 0.62 0.4 0.25 0.06 1.0 0.19 0.03 0.02

This material was melted in the United States or a Qualifying Country [REF DPARS 225.872.1(a)]; it was manufactured in the United States